

**AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**LISTING OF CLAIMS:**

---

1. (Currently Amended) A method of dry milling a material comprising:

providing a milling cutter with a silicon nitride based milling insert;

advancing the milling cutter relative to the material such that at least the majority of material removal is accomplished by contact with the milling insert;

cutting at a cutting speed of 1000-3000 m/min; and

feeding to a cutting depth of 0.2-2 mm,

wherein the material comprises aluminum and cast iron.

2. (Previously Presented) The method of claim 1, wherein the insert produces a chip thickness of 0.09-0.17 mm.

3. (Currently Amended) A method of dry milling a composite material, the method comprising:

providing a milling cutter with a silicon nitride based milling insert;

advancing the milling cutter relative to the material such that at least the majority of material removal is accomplished by contact with the milling insert;

C1  
cutting at a speed of 1100-2500 m/min; and  
feeding to a cutting depth of 0.2-2 mm.

4. (Previously Presented) The method of claim 3, wherein the cutting depth is  
0.3-1.0 mm.

---